

Work Order ID 151447***151447***

Page 1

Tuesday, September 27, 2016 11:53:43 AM

Item ID: D3685-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bipod Mount Assembly
Start Date: 9/22/2016 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 9/27/2016 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 27 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3685	F

100	Pick Kit	0.00
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100

Packaging

Memo

0.00

Packaging

DAS 6 9-89**JAN 1 2017**

110	Small Fab	0.00
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110

Small Fab

Memo

0.67

Small Fab

DAS 19 9-89**JAN 17 2017**

1-Align the pilot holes in mating parts. Drill out each hole using pilot drill and ream each hole using a step reamer. Clean and deburr all holes prior to assembly as per dwg. (SEE NOTE 8)

AFTER FINISH DRILLING AND REAMING PARTS MUST STAY TOGETHER. DO NOT MIXE THEM UP

2-Assemble D3684-049/-047 & D3687-3 Using Hysol EA934NA or MAGNOBOND 6398 adhesive between mating surfaces as per Dwg D3684

MAGNOBOND BATCH:

B134167

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval 	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120						2			DAS 38 9-89
QC	Memo	0.01							JAN 17 2017
Quality Control									
130	Identify as per dwg & Stock Location: <u>51230</u>	0.00							
130						2			DAS 6 9-89
Packaging	Memo	0.00							JAN 20 2017
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									DAS 21 9-89
QC	Memo	0.03							JAN 23 2017
Quality Control									

 JAN 20 2017

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		OTHER : ☐			

Picklist Print

Tuesday, September 27, 2016 11:53:42 AM

Page 1

Work Order ID: 151447

151447

Parent Item: D3685-041

D3685-041

Parent Item Name: Bipod Mount Assembly

Start Date: 9/22/2016

Required Date: 9/27/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3684-047		Manufactured	No				Each	0.0000		2			
D3684-047									**	144863			
Fwd Leg Assembly													
D3684-049		Manufactured	No				Each	0.0000		2			
D3684-049									**	144865			
Aft Leg Assembly													
D3687-3		Manufactured	No				Each	4.0000		2			
D3687-3									**				
Mount													
				<u>Location</u>		<u>Loc Qty</u>							
				GA		4				2			
				93757		4							
HL32PB8-14		Purchased	No				Each	101.0000		8			
HI 32PB8-14									**				
Replacement Hi-Lok Pin													
				<u>Location</u>		<u>Loc Qty</u>							
				ST562		101				2			
				m128179		2							
				m128454		59				5			
				m134180		40							

DAS 6 JAN 12 2017
 DAS 6 JAN 12 2017
 FF
 DAS 6 JAN 12 2017

DQA: _____ Date: _____



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Parent Item: D3685-041

D3685-041

Parent Item Name: Bipod Mount Assembly

Start Date: 9/22/2016

Required Date: 9/27/2016

Start Qty: 2.00

Required Qty: 2.00

HL86-8

Purchased

No

Each

96.0000

8

HI 86-8

OAS
6
2-89

JAN 12 2017

Collar

Location

Loc Qty

Loc Code

ST562

96

m127815

2

m131803

74

m134180

20

2
2

DQA: _____ Date: _____



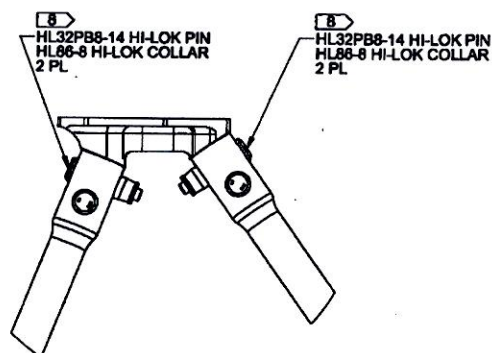
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

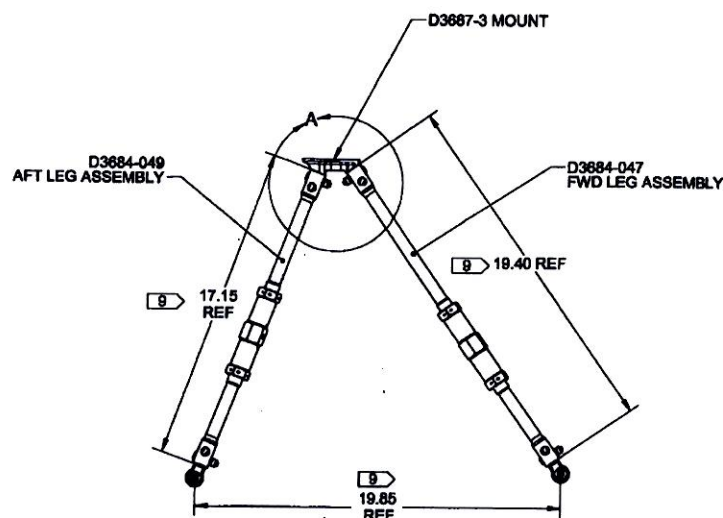
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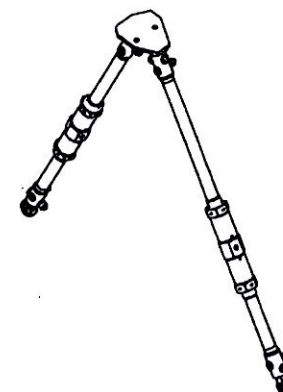
ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D3685-041	BIPOD MOUNT ASSEMBLY
1	1	D3687-3	MOUNT
2	1	D3684-047	FWD LEG ASSEMBLY
3	1	D3684-049	AFT LEG ASSEMBLY
4	4	HL32PB8-14	HI-LOK PIN
5	4	HL86-8	HI-LOK COLLAR



DETAIL A
SCALE 3X



D3685-041 BIPOD MOUNT ASSEMBLY



RELEASED
2013-12-06

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) ALIGN THE PILOT HOLES IN MATING PARTS. DRILL OUT EACH HOLE USING A P/N 13-420 PILOTED DRILL (0.2314 DIA./0.2158 PILOT). REAM EACH HOLE USING A P/N 44-300 STEP REAMER (0.247 DIA./0.2314 PILOT). CLEAN AND DEBURR ALL HOLES PRIOR TO ASSEMBLY. ASSEMBLE D3684-047/-049 WITH D3687-3 USING HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE BETWEEN MATING SURFACES. HI-LOK PIN ORIENTATION AS PER DETAIL 'A'.
- 9) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-041 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES

F	ADD DETAIL A. REVERSE THE INSTALLATION ORIENTATION OF HI-LOK PINS TO FACILITATE ASSEMBLY PROCEDURE. CORRECT BOM TABLE	DB	13.11.18
E	REMOVE ANSC-12A BOLT, D3692-1 SPACER AND MS21043-3 NUT. REPLACE WITH HL32PB8-14 HI-LOK PIN, HL86-8 HI-LOK COLLAR (ZN C5-1). RE-FORMAT NOTES SECTION AS PER QSI 041. CHANGE ASSEMBLY ADHESIVES. NOTES (ZN A5-1). CHANGE BOM TABLE TO REFLECT NEW ASSEMBLY STRUCTURE. (ZN D6-1) REF NCR 12-2074	DB	12.12.05
F	17.15 WAS 17.27 (ZN B5-1); 19.40 WAS 19.82 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	06.12.15
B	19.82 WAS 19.85 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	06.11.24
A	NEW ISSUE	RF	06.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.11.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3685

REV. F
SHEET 1 OF 1

TITLE
BIPOD MOUNT ASSEMBLY

SCALE
NTS

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